

Date: Tuesday, 1/15/2008 3:08:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	412 X-TUBE, LOW NARROW AFT		
Job Number	36770			Part Number	D412664209		
Estimate Number	13020			Drawing Number	D412-664-209 <i>HR A</i>		
P.O. Number	:			Project Number	N/A		
This Issue	1/15/2008	S.O. No.	:	Drawing Revision	<i>HR A</i>		
Prsht Rev.	NC			Material	:		
First Issue	1/15/2008	Type	LANDING GEAR	Due Date	2/4/2008	Qty:	1
Previous Run	36769			Um:	Each		
Written By	<i>HR A 08-01-15</i>						
Checked & Approved By							
Comment	Est Rev:A New Issue 07.09.12 EC verified by: JLM						
	Est Rev:B ECN 1100 08-01-11 DD verified by EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	DC	DOCUMENT CONTROL  <i>KS 08-01-29</i>
2.0	D6008132	Photocopy bluefile and create labels as per PPP D212-664-209 CHG001  <i>KS 08-01-29</i>
3.0	MORI SEIKI	Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D212-664-209 CHG001  <i>KS 08-01-29</i>
4.0	QC2	Comment: 1-TURN AS PER FOLIO FA708 & DWG D412-664-249, FOLIO REV: <i>AA</i> DWG REV: <i>XX A</i> 2-DEBURR AS REQUIRED  <i>J.F. 08/01/18 (1)</i>
5.0	QC8	Comment: INSPECT PARTS AS THEY COME OFF MACHINE  <i>J.F. 08/01/18 (1)</i>
		Comment: SECOND CHECK  <i>9/1 08/01/21 (1)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE, LOW NARROW AFT

Job Number: 36770

Part Number: D412664209

Job Number:



Seq. #

Machine Or Operation:

Description:

6.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

INSPECT WORK TO CURRENT STEP

QC6

Comment: INSPECT WORK TO CURRENT STEP

8-1-21

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8-1-21 ①

9.0 QC3/5

INSPECT WORK/WING WALK

Comment: Inspect work & Chemical conversion Coat

8-1-22 ①

10.0 BENDING

BENDING MACHINE

Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-249 using CNC bender program and Follo: FT

8-1-25

11.0 QC6

DIMENSIONAL CHECK

① PTD

Comment: DIMENSIONAL CHECK

8-1-25

12.0 D36601

CUFF

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CUFF

Batch: B 36835

② 8-2-7

13.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1.0 Cut to height EL/SD 8-2-7

1-Drill Rivet holes as per Dwg D412-664-249

2-Drill pilot holes in tube as per Dwg D412-664-249

3-Ream hole to finish size in tube as per Dwg D412-664-249

③ 8-2-7

W/O: \_\_\_\_\_

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/25	II.1	Cut & trim to correct height as per drawing D412-664-249 Add to I.P.P. Permit change				08-02-01	08/01/25
08/01/25	II.2	Inspect height after cutting. QC #15 Permit change.				08-02-01	08-02-01

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes No DQA: \_\_\_\_\_

Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Tuesday, 1/15/2008 3:08:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE ,LOW NARROW AFT

Job Number: 36770

Part Number: D412664209

Job Number:



Seq. #:

Machine Or Operation:

Description:

*AWM 8-02-11*

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-249

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



*ANM 08-02-11*



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*8/02/14 (4)*

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8/02/14 (4)*

17.0 OUTSIDE SERV.10

OUTSIDE SERVICES LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 5729 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*8/02/14 (1)*

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order

*8/02/14 (1)*

19.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

20.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D412-664-249. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/291 BATCH: M105 488

*8/02/14 (1)*

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

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Drawing Name: 412 X-TUBE, LOW NARROW AFT

Job Number: 36770

Part Number: D412664209

Job Number:



Seq. #: Machine Or Operation:

Description:

21.0 CR3212407 CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

CHERRY RIVET

Batch: M104071

EL 8-2-19

22.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ST 08-02-19

23.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

24.0 D28961 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Support

Batch: 33471

ST 08/02/21

25.0 D31891 Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Chafing Shield

Batch: 37185

ST 08-02-20

26.0 D3595 Rubber Cushion (per sq ft)



03595063570 2008/2/27

Comment: Qty.: 0.0263 sf(s)/Unit Total: 0.0263 sf(s)

Rubber Cushion

Cut to .630" X 5.70" Qty 2

Batch: 35126

W 08 02 21

27.0 MS2192028 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp

Batch: 104423/106864<sup>2</sup>

ST 08-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE, LOW NARROW AFT

Job Number: 36770

Part Number: D412664209

Job Number:



Seq. #: Machine Or Operation:

Description :

28.0 MS2192030 clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
clamp(per MIL-DTL-8783C)

M106810

M 08 02 21

29.0 D28566001009 Abrasion strip



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Abrasion strip  
batch B36398

BT 08-02-21

30.0 AN640A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
batch M106516

31.0 AN641A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt

M107427

32.0 MS21042L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Nut  
batch M105077

33.0 AN960JD616 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Washer  
batch M106883

34.0 LANDING GEAR RESOURCE 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
Assemble as per Dwg D412-664-249

B105379  
exp: 05/2008

Instal support with magnobond 6398 per dwg D412-664-249,  
cure for 12hrs before packaging.

Time & date of application: 08/02/21 10:30am

M 08/02/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: LD Date: 08/01/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE, LOW NARROW AFT

Job Number: 36770

Part Number: D412664209

Job Number:



Seq. #: Machine Or Operation:

Description :

Batch:

350231 QC5

INSPECT WORK TO CURRENT STEP



31 Jan 2008



Comment: INSPECT WORK TO CURRENT STEP

36038

PACKAGING 1

PACKAGING RESOURCE #1



Draft 8h27sd(1x)



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-209

37039

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Jan 2008 12/27

Job Completion



2008 12/27 ①

37) QC4 Jan 2008 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36770
Description:	Crosstube Assembly (412 Low Aft)	Part Number:	D412-664-249
Inspection Dwg:	D412-664-249	Rev:	A

Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A						
$\varnothing 2.680$	$\pm .005$	2.680	✓			
$\varnothing 2.687$	$\pm .005$	2.692	✓			
$\varnothing 2.793$	$\pm .005$	2.798	✓			
$\varnothing 2.930$	$\pm .005$	2.935	✓			
$\varnothing 3.067$	$\pm .005$	3.072	✓			
$\varnothing 3.205$	$\pm .005$	3.209	✓			
$\varnothing 3.358$	$\pm .005$	3.361	✓			
127.82	$\pm .020$	127.820	✓			
SIDE B						
$\varnothing 2.680$	$\pm .005$	$\varnothing 2.682$	✓			
$\varnothing 2.687$	$\pm .005$	$\varnothing 2.690$	✓			
$\varnothing 2.793$	$\pm .005$	$\varnothing 2.795$	✓			
$\varnothing 2.930$	$\pm .005$	$\varnothing 2.932$	✓			
$\varnothing 3.067$	$\pm .005$	$\varnothing 3.069$	✓			
$\varnothing 3.205$	$\pm .005$	$\varnothing 3.210$	✓			
$\varnothing 3.358$	$\pm .005$	$\varnothing 3.362$	✓			

Measured by:	J.F.	Audited by:	Spk	Prototype Approval:	N/A
Date:	08/01/18	Date:	08/01/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	(P/O D212-664-209)	KJ/EC/DD

DART AEROSPACE LTD

Work Order: 36770

Description: Crosstube Low Aft (412)

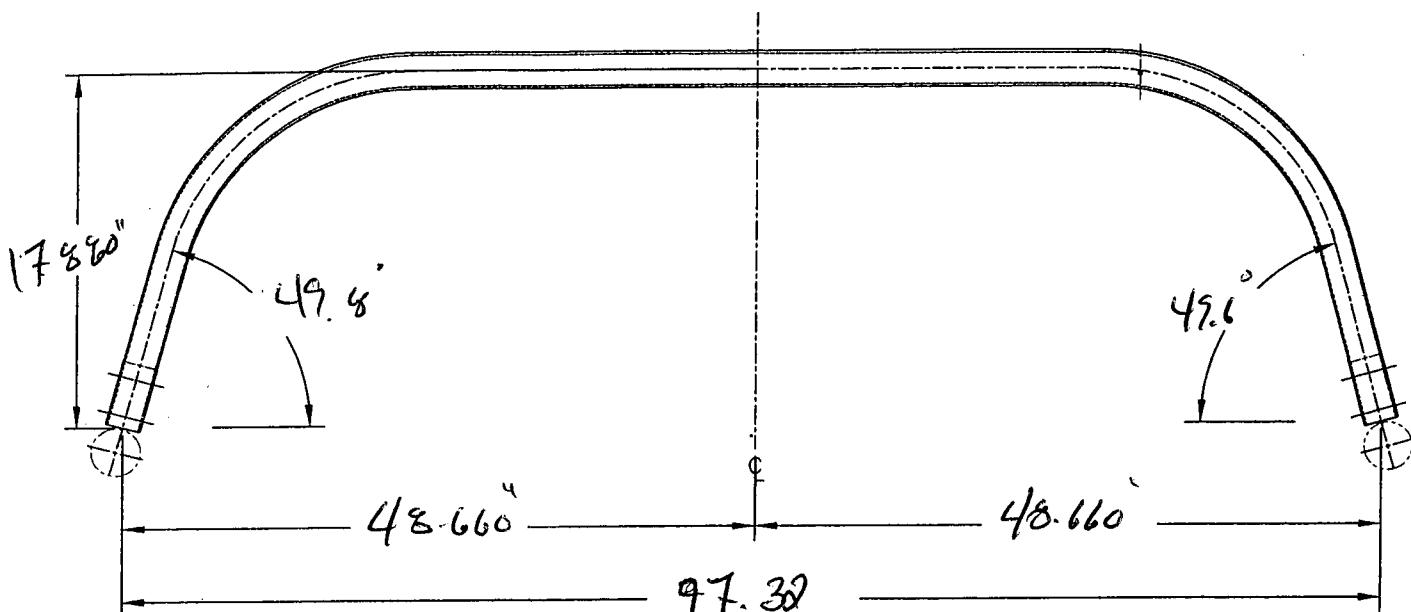
Part Number: D212-664-209

Inspection Dwg: D212-664-249

Rev: A

Page 1 of 1

Required Dimension	Min	Max
Height	17.78	18.04
1/2 Span	46.55	48.81
Angle	49.1	52
Total Span	97.1	97.62



Comments

QC15 Inspection	08/01/25	09.02.01
Date		

Rev	Date	Change	Revised by	Approved
A		New Issue		

**PARTS LIST:**

Qty	Part Number	Description
X	D412-664-249	CROSSTUBE ASSEMBLY (412 LOW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-570	RUBBER CUSHION
2	D3660-1	CUFF
44	CR3212-4-07	RIVET (OR M7885/3-4-07)
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH =  $127.82 \pm 0.020$  (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK, BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A  
VIBRATING STYLUS.
- 10) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF  
CROSSTUBE PER QSI 035.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) APPLY 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1  
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER  
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE  
D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.
- 14) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY  
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A  
LAYER OF SIKAFLEX-241-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN  
CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 16) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

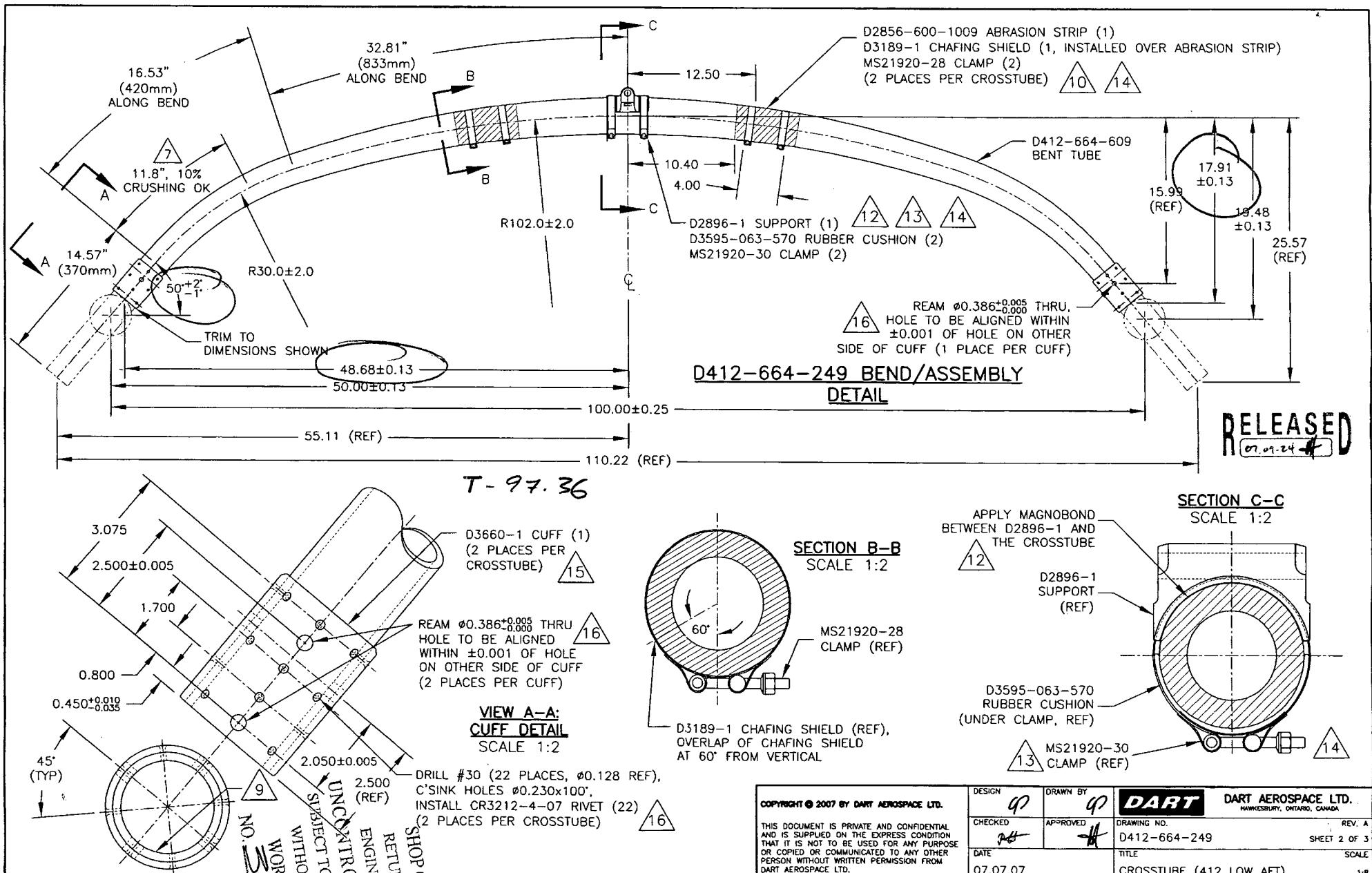
RELEASED  
07.01.24

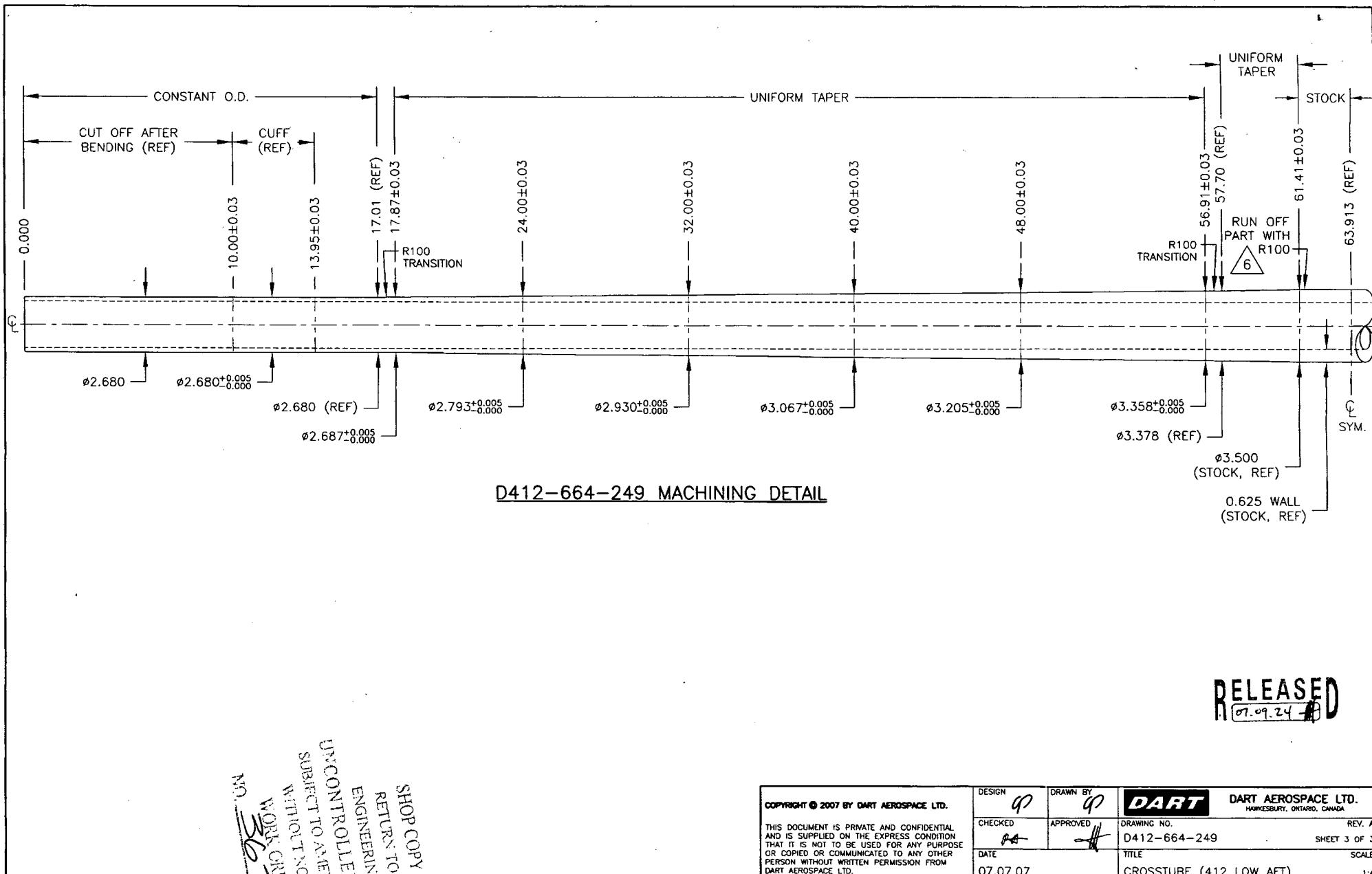
NO. 36  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

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DART AEROSPACE LTD.

A	07.07.07	NEW ISSUE
DESIGN	9P	DRAWN BY 9P
CHECKED	9P	APPROVED 9P
DATE	07.07.07	TITLE CROSSTUBE (412 LOW AFT) NTS
DRAWING NO.	D412-664-249	REV. A
DATE	07.07.07	SHEET 1 OF 3
DATE	07.07.07	SCALE

DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADA







ACUREN

P- 09830

## LIQUID PENETRANT TEST REPORT

CLIENT Dart AREOSPACE DATE Feb. 15, 2008  
 ATTENTION Linda Lacelle TIME 188 - 08/220  
 ADDRESS 1270 Aberdeen st. PO/WO NO. S729  
Hawkesbury ontario WORK LOCATION Hawkesbury  
 ACCEPTANCE STD. ASTM 1417/051-03 REV./DATE 2005

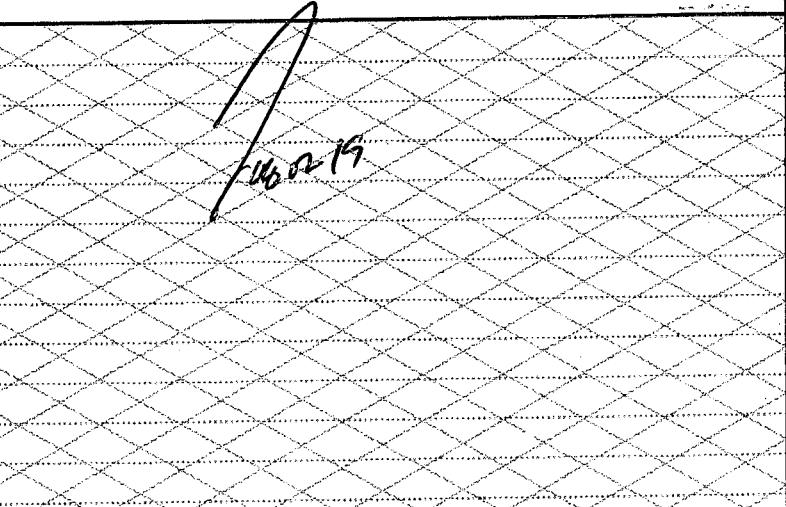
PROJECT 212 X-TUBE, LOW NARROW AFT and FWD, 407 HIGH AFT X-TUBE ASSEMBLY, 412 X-TUBE LOW NARROW AFT  
 ITEM(S) EXAMINED Job# 36642 - 36644 - 36645 - 36768 - 36770 - 36773 - 37009 - 37010

JOB DESCRIPTION	PROCEDURE NO. LT-XXXX REV./DATE	TECHNIQUE NO. LT-XXXX-XXX REV./DATE
PART NO. D212664107-D212664307- <del>0412664301</del> 0412664301-0412664305 MATERIAL ALLOYDYNED ALUMINUM/STEEL		
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE	
TEST DETAILS		
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	Magnaflex	
PENETRANT	ZL67	MINIMUM DWELL TIME <u>405</u> MIN.
PENETRANT REMOVER	H2O	MINIMUM DRY TIME <u>&gt;10</u> MIN.
DEVELOPER	SKDS2	MINIMUM DWELL TIME <u>10</u> MIN.
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	CAL DUE DATE <u>MAR 08</u>

TEST SURFACE

SURFACE CONDITION	<input checked="" type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS- ( <input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL )	ITEM	COMMENTS	ACCEPT	REJECT
Sub# 36642: ACCEPTABLE				
36644: ACCEPTABLE				
36645: ACCEPTABLE				
36768: ACCEPTABLE				
36770: ACCEPTABLE				
36773: ACCEPTABLE				
37009: ACCEPTABLE				
37010: ACCEPTABLE				

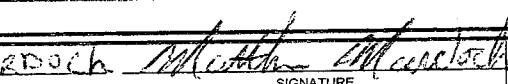
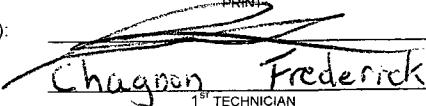


*Feb 21 08*

Scope of Services  
 The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care  
 In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE	<u>Matthew Murdoch</u> 	PRINT 	SIGNATURE 	DTR #
TECHNICIAN (SIGNATURE):				REPORT REVIEWED BY:
NAME (PRINT):	<u>Chagnon</u>	<u>Frederick</u>	1 <sup>ST</sup> TECHNICIAN	NAME 
CGSB LEVEL	<u>II</u>	SNT LEVEL	2 <sup>ND</sup> TECHNICIAN	INITIALS 
CGSB REG. NO.	<u>10560</u>		CGSB LEVEL SNT LEVEL	
CGSB REG. NO.			CGSB REG. NO.	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY